Work Ord Friday, June 04												Page 1
Item ID: Revision ID:	D4022-041			Accept					Setup		1 18811181 811	
Item Name: Start Date: Required Date Reference:	6/4/2010	Pump Assembly Start Qty: 1.00 Req'd Qty: 1.00			Cust Item l Customer:	D:				Stop		
Approvals:	Process Pla	nn:	Date:/ <i>O-6-07</i>	Tooling: SPC (Y/N):		ate:		1		Start Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr D4022 100 Small Fab Small Fab	A	1	per dwg D4022	0.00	7ml	s/11/	()			
110 QC Quality Control	B10-11-16	metalset QC5-Inspect part compl Memo		0.00	1u/17	, (A)				

120

Identify as per dwg & Stock Location: 13

Memo

0.00

Packaging

Packaging

0.00

lu co/11/17(1)

W/O:			WC	ORK ORDER CHANG	GES	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1				
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,	
*										
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes	No DQ	A:	Date: _	
		esolution:								
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC Corrective Actio			Ver			cation	Approval	Approval
	JILI	Section A	Initial Chief Eng	Initial Action Description Chief Eng Chief Eng		Sign & Section C			Chief Eng	QC Inspector
-					,					
									į	

Work Order ID 59511

Friday, June 04, 2010 3:03:39 PM



Page 2

Item ID:

D4022-041

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name: Fuel Transfer Pump Assembly

Required Date: 6/10/2010

6/4/2010

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description

Cust Item ID: Customer:

Reference:

А	nr	۱rc	V2	ls:	

Process Plan:

QC21- Final Inspection - Work Order Release

Date:

Tooling:

Date:

Start Run

Reject

Qty

QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/

Work Center ID

130

Memo

Tool ID

Tool # Plan Code

Accept Qty

Reject Number

Insp. Stamp

QC **Quality Control**

0.00

0.00

	-								
W/O:			WC	RK ORDER CHANG	ES		<u> </u>		
DATE	STEP	PROC	EDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·					
Part No	:	PAR #:	_ Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	_ Disposition	n:	_ QA: N/C (Closed:		Date: _	
NCR:		W	ORK ORDE	ER NON-CONFORMA	ANCE (NC	R)			-
DATE	STEP	Description of NC		on B	Verifi	cation	Approval	Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector

Picklist Print

Friday, June 04, 2010 3:03:43 PM

Work Order ID: 59511

Parent Item Name:

Parent Item:

D4022-041

Fuel Transfer Pump Assembly

Comments:

IPP rev A 10.02.02 new issue Prelim EC verified by:DD

Start Date: 6/4/2010

Required Date: 6/10/2010

Page 1

Start Qty: 1.00

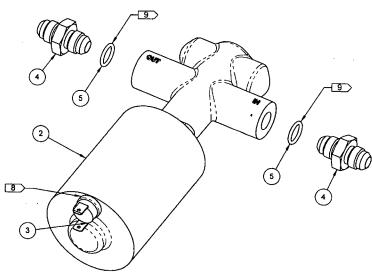
Required Oty: 1.00

10	0.05.17 as per EC	N10-562 DD ver		vormed by.	DD III K	CV.D			start Qty. 1.00		Require	u Qiy: 1.	00
Component Item ID/ Item Name D4022-1 Fuel Transfer Pump	Replacement Item ID	Mfg/ Purch Manufactured	Bin Item No	Primary Location	Last Location	Route Seq ID 100	Unit of Measure Each	0.0000	Qty per Kit	Total Otv 1	Qty Issued	Date Issued	Status ////6
D4022-5 Thermal Switch		Manufactured	No			100	Each	9.0000	1 	1 M	1	w/.	11/16
				<u>Location</u> ENG	55518	<u>Loc</u>	Oty 9 9	Loc Code			-	,	
AN815-6D		Purchased	No		33310	100	Each	8.0000	2	²	n-L	10/	11/16
				Location ST329	114348 114523	<u>Loc</u>	8 14 L 3 5	Loc Code 1 4977	_	2_	-	•	
MS29512-06		Purchased	No			100	Each	27.0000	2	2 M	1	١١/دا	/16
				<u>Location</u> ST294	113691 114742	<u>Loc</u>	Oty 27 7 20	Loc Code	 	2	- - -		

IPP Rev:B

	•									N.	- · · · · · · · · · · · · · · · · · · ·
W/O:				V	ORK ORDER	CHANGES				~·	
DATE	STEP		PROCI	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										· ·	
Part No	:	PAR	l #:	Fault Ca	tegory:		NCR: Yes	No DQ	\:	Date:	
	Resolution:									Date:	
NCR:			WC	ORK OR	DER NON-CO	NFORMAN	CE (NCR)			
DATE	STEP	Description of NC	NC	Corrective Action Initial Action Descript			Section B Verification Sign & Section B			Approval	Approval
		Section A	<u> </u>	Initial Chief Eng	Chief		Date	Section	on C	Chief Eng	QC Inspector
	:									,	
	, 		•								
 ,	,										
	•	,			,	•					***
					i			,			

	<u> </u>	÷ • • • • • • • • • • • • • • • • • • •	, 5
QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
X	D4022-041	FUEL TRANSFER PUMP ASSEMBLY	A8150-B1-JCA
1	D4022-1	FUEL TRANSFER PUMP	
1	D4022-5	THERMAL SWITCH	
2	AN818-6D	FITTING, UNION	
2	MS29512-06	O RING	
		1 D4022-1 1 D4022-5 2 AN818-6D	The full transfer pump assembly



SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COTY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDI-R NO. 5951/ NO. 595-07

2

3

D4022-041 FUEL TRANSFER PUMP ASSEMBLY

NOTES:		
1) MATERIAL	N/A	

D

1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4022-041" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.61 lbs
8) ATTACH D4022-5 THERMAL SWITCH TO D4022-1 FUEL PUMP IN LOCATION SHOWN USING METALSET A4
9) LUBRICATE O-RING WITH ULTRACHEM ASSEMBLY FLUID #1, FUEL-LUBE, MOLYKOTE 55 O-RING GREASE OR EQUIVALENT

Α NEW ISSUE 10.04.16 REV. DESCRIPTION DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4022 MFG. APPR. SHEET 1 OF 4 APPROVED TITLE SCALE **FUEL PUMP** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THE DOCUMENTS PRINKE AND CONFORMAL AND IS EXPRESS OF THE DAYS SO CONTROL TO TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON. DATE 10.04.16

8

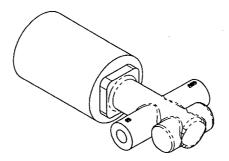
3

D

С

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									-
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	_ Date: _	<u>_</u>
	Res	solution:	Disposition	n:	_ QA: N/C CI	osed:		Date:	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section	Verification		Approval	Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	ion C	Chief Eng	QC Inspector

D



alo 59511

D

С

2

DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	OPERATING VOLTAGE	FLOW (GPH)	OUTPUT PRESSURE (PSI)	TEMPERATURE RANGE
D	WELDON	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F
D4022-1	AEROSPACE ACCESSORIES	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F

D4022-X FUEL TRANSFER PUMP

	DESIGN DART AER	ROSPACE LTD
NOTES: 1) MATERIAL: N/A		, ONTARIO, CANADA
1) MATERIAL: N/A 2) FINISH: N/A	CHECKED B DRAWING NO.	R
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED	MFG. APPR. P. D4022	SHEET
4) UNITS: INCHES UNLESS OTHERWISE NOTED	APPROVED (16), TITLE	
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A	DE APPR. FUEL. PUMP	
7) WEIGHT: 2.6 lbs	DATE 10.04.16 THIS COCUMENT OF A PRIVATE AND COPPED THAN A PRIVATE AND COPPED THAN A PRIVATE AND COPPED THAN A PRIVATE AND COPPED CONTROL OF A COPPED THAN A PRIVATE AND COPPED CONTROL OF A COPPED THAN A PRIVATE AND COPPED CONTROL OF A COPPED THAN A PRIVATE AND COPPED COPPED THAN A PRIVATE AND COPPED THA	

3

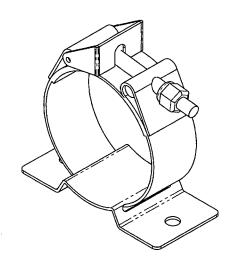
REV. A SHEET 2 OF 4 SCALE

8

W/O:			WC	ORK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	s No DQ	A:	Date:	
		solution:							
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NC	R)	***************************************		
DATE	STEP	Description of NC Corrective Action			tion B	Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Action Descrip Chief Eng Chief Eng		Sign Dat	'&r Sect	K Section C		QC Inspector
									,
					,				
]				

DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4022-3 REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS MOTOR SIZE
	WELDON	TC 250-100	STAINLESS STEEL	2.5
D4022-3	AIRCRAFT SPRUCE AND SPECIALTY	05-00021	STAINLESS STEEL	2.5
	AEROSPACE ACCESSORIES	TC 250-100	STAINLESS STEEL	2.5

D4022-X FUEL PUMP MOUNTING BRACKET



D

С

В

NOTES:	
1) MATERIAL: N/A	
2) FINISH: N/A	

2) FINISH: NAS
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.33 lbs

8

DESIGN		DART AEROSPACE LTD			
DRAWN	65	HAWKESBURY, ONTARIO, CANADA			
CHECKED	B	DRAWING NO.	REV. A		
MFG. APPR.	是	D4022	SHEET 3 OF 4		
APPROVED	NP	TITLE	SCALE		
DE APPR.		FUEL PUMP	NTS		
DATE 10.0	4.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVAT AND DOCUMENT HOUSE CONFIDENCE OF THE DEPARTS CONTINUED THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF CORPOR OF COMMUNICATION TO MAY OTHER PERSON WITHOUT			

3

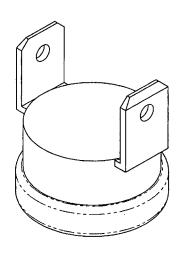
D

W/O:			WO	RK ORDER CHANG	ES		····································			
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
						·				
Part No		PAR #:								
Resolution: Di			Disposition	:	_ QA: N/C CI	QA: N/C Closed: Date			:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Section C	Chief Eng	QC Inspector	
								-		

DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4022-5 REF JCA/M47/D3/SHT 13

D

SPECIFICATION CONTROL DRAWING



www 59511

2

DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	ALTERNATE PART NUMBER	TEMPERATURE WHEN SWITCH OPENS
	FARNELL	1006847	3775628	125°F
D4022-5	HONEST-WELL	T23A125BSR2-15	3775628	125°F
	NEWARK	98K1992	3775628	125°F

D4022-X THERMAL SWITCH



NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.00 lbs

DESIGN	45	DART AEROSPACE LTD			
DRAWN	1	HAWKESBURY, ONTAI			
CHECKED	B	DRAWING NO.	REV. A		
MFG. APPR.	8	D4022	SHEET 4 OF 4		
APPROVED	140	TITLE	SCALE		
DE APPR.	4	FUEL PUMP	NTS		
DATE 10.0	94.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS WHANTE AND COME DEFINIAL AND EXPENDED OF THE CHRESS CONSTITUTING THE S MOT TO BE USED FOR NOT ARROPED OR COMMENCE TO SAMP OTHER POSSON WITHOUT			

3

2

5

Dart A	Aeros	pace	Ltd
--------	-------	------	-----

W/O:			W	ORK ORDER CHANG	iES .			
DATE STEP		PROCEDURE CHANGE			Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-			
				11 - 1				
Part No		PAR #:						
Resolution:			Dispositio	n:	_ QA: N/C Cld	QA: N/C Closed: Date:		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description		ion B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date	Section C	Office Eng	QC IIIspector
	-	•			:			
						<u> </u>	<u>·</u>	
		·.				ļ.		<u> </u>
	.					. * .		
		<u> </u>						